

5/03

**DART AEROSPACE LTD**

**Work Order:**

22049

**Description:** Fitting

**Part Number:**

D3299-1

**Dwg:** D3299 Rev. A1

**Qty:**

9

Page 1 of 1

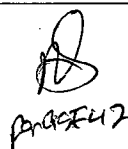
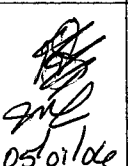
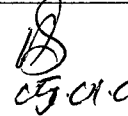
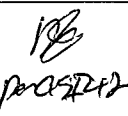
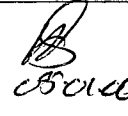

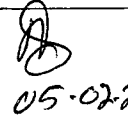
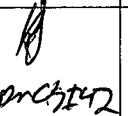
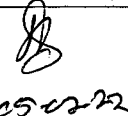
Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JA	04.12.08	10
2	MC	Cut blank: 2.200" long Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.625" Hex (M6061T6H1.625) <b>Identify as D3299-1</b> Batch: <u>M15717</u>	ml	05/01/04	10
3	MC	Turn as per Folio FA451 and Dwg D3299	ml	05/01/06	10
4	QC2	Inspect parts as they come off the CNC machine	ml	05/01/06	10
5	MV	Machine as per Folio FA451 and Dwg D3299	ml	05/02/02	9
6	QC2	Inspect parts as they come off the CNC machine	ml	05/02/02	9
7	QC8	Second check	PC	05.02.22	9
8	MV	Deburr	ml	05/02/02	9
9	PG	Issue P/O: <u>2007621</u> Anodize as per Dwg D3299 Possible Supplier: TNM Paint <b>Material release note is required</b>	U	05/02/23	9
10	RG	Receive and Inspect for transit damage <b>Ensure material release note is attached</b>	CL	05/02/28	9
11	QC5	Inspect work to Step 10	J	05.03.01	9
12	ST	Identify and Stock	CL	05/03/02	9
13	AC	<del>Identify with Dart Part #</del> Batch # <u>0503AFINE</u> Paint <u>Recurrent</u> <del>marked</del> Cost / part: <u>38.27</u>	Sut	05-03-03	9
14	DC	Close W/O <u>36,34</u> Inspect Level 21			

(Pto)

Rev	Date	Change	Revised By	Approved
A	04.10.04	New issue	KJ/JLM	

**RELEASED**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/01/06	3	1 piece scrap first run	 prch12	destroy & replace	 05/01/06	 05-01-06	 prch12	 05-01-06
05/02/02	5	1 piece scrap dwg was wrong	 prch12	destroy & reth		 05-02-02	 prch12	 05-02-02

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>22049</b>
<b>Description:</b> Fitting		<b>Part Number:</b>	<b>D3299-1</b>
<b>Inspection Dwg:</b> D3299	<b>Rev:</b> A1 <i>04.11.16</i>	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.030	1.25	✓		Vern	
0.476	+0.000/-0.005	0.475	✓		Vern	
0.550	+/-0.010	0.547	✓		Vern	
1.00	+/-0.030	0.999	✓		Vern	
2.10	+/-0.030	2.096	✓		Vern	
0.773	+/-0.010	0.780	✓		Vern	
0.10	+/-0.030	0.085	✓		Vern	
0.20	+/-0.030	0.201	✓		Vern	
0.550	+/-0.010	0.544	✓		Vern	
MOW Max = 0.573 Min = 0.565	Max = 0.573	0.5703	✓		Micr	
Ø0.302	+0.005/-0.000	Ø0.306	✓		Vern	
Ø0.688	+0.005/-0.000	Ø0.690	✓		Vern	
Ø0.580	+0.005/-0.000	Ø0.582	✓		Vern	
53°	+/-0.5°	53°	✓		Vern	

<b>Measured by:</b> <i>gml</i>	<b>Audited by:</b> <i>R</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> <i>05/01/06</i>	<b>Date:</b> <i>05.02.22</i>	<b>Date:</b>	N/A

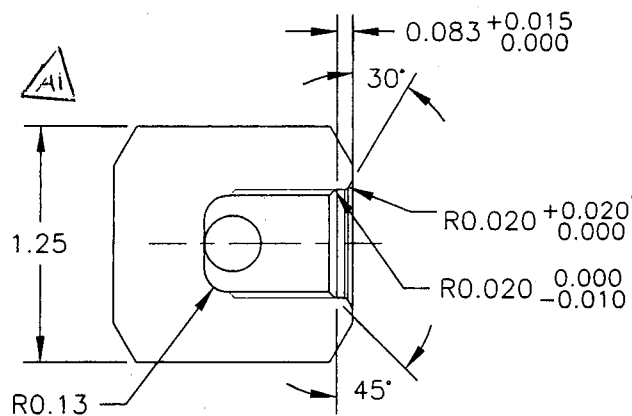
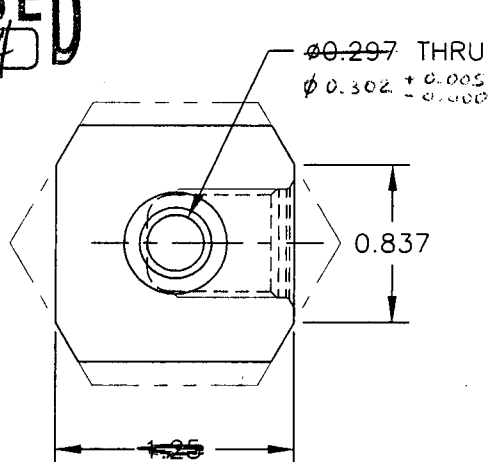
Rev	Date	Change	Revised by	Approved
A	04.11.12	New Issue	KJ/JLM	<i>[Signature]</i>

**RELEASED**  
*04/01/11.15*

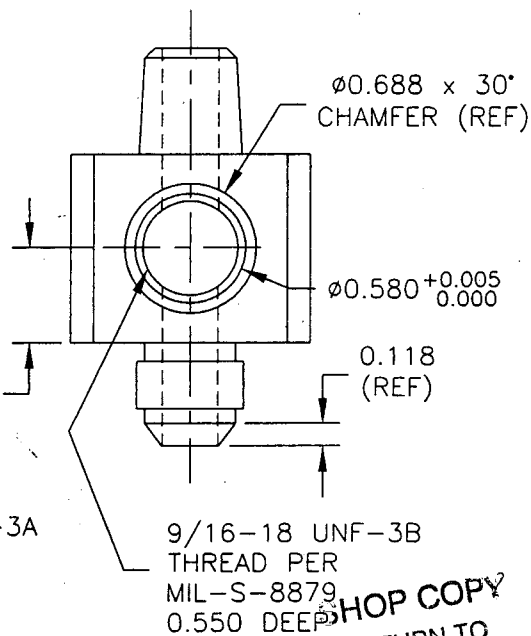
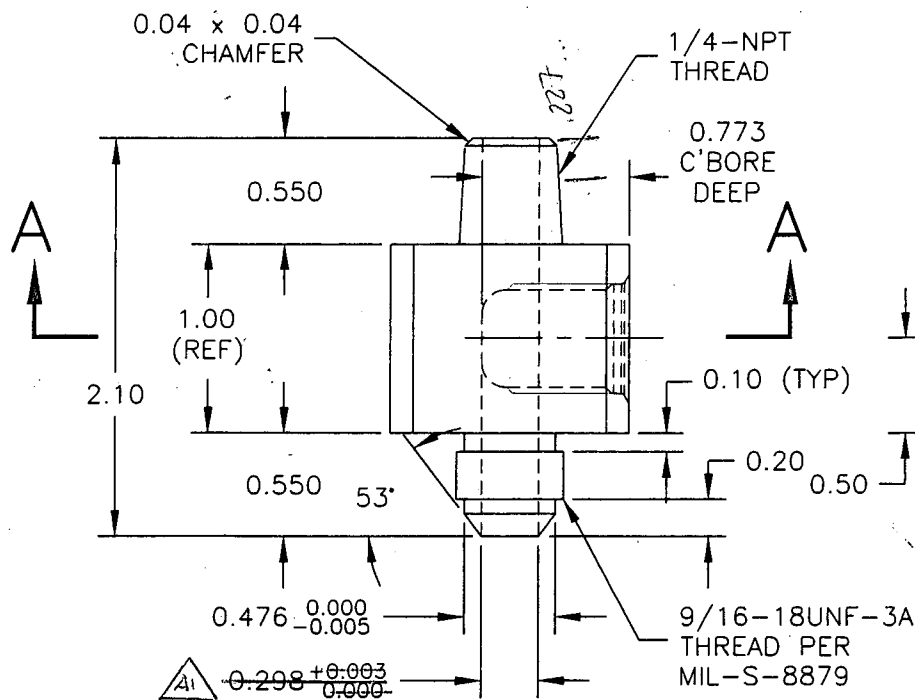


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3299	REV. A SHEET 1 OF 3
DATE 04.07.06	TITLE FITTING	SCALE 1:1	
A	04.07.06	NEW ISSUE	
A1	04.11.15	#0.302 WAS #0.297; ADD #0.540, R0.13	

RELEASED  
04.09.09 #



SECTION A-A



D3299-1

D3299-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1-625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR III (CLASS 2)  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCLASSIFIED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 22049

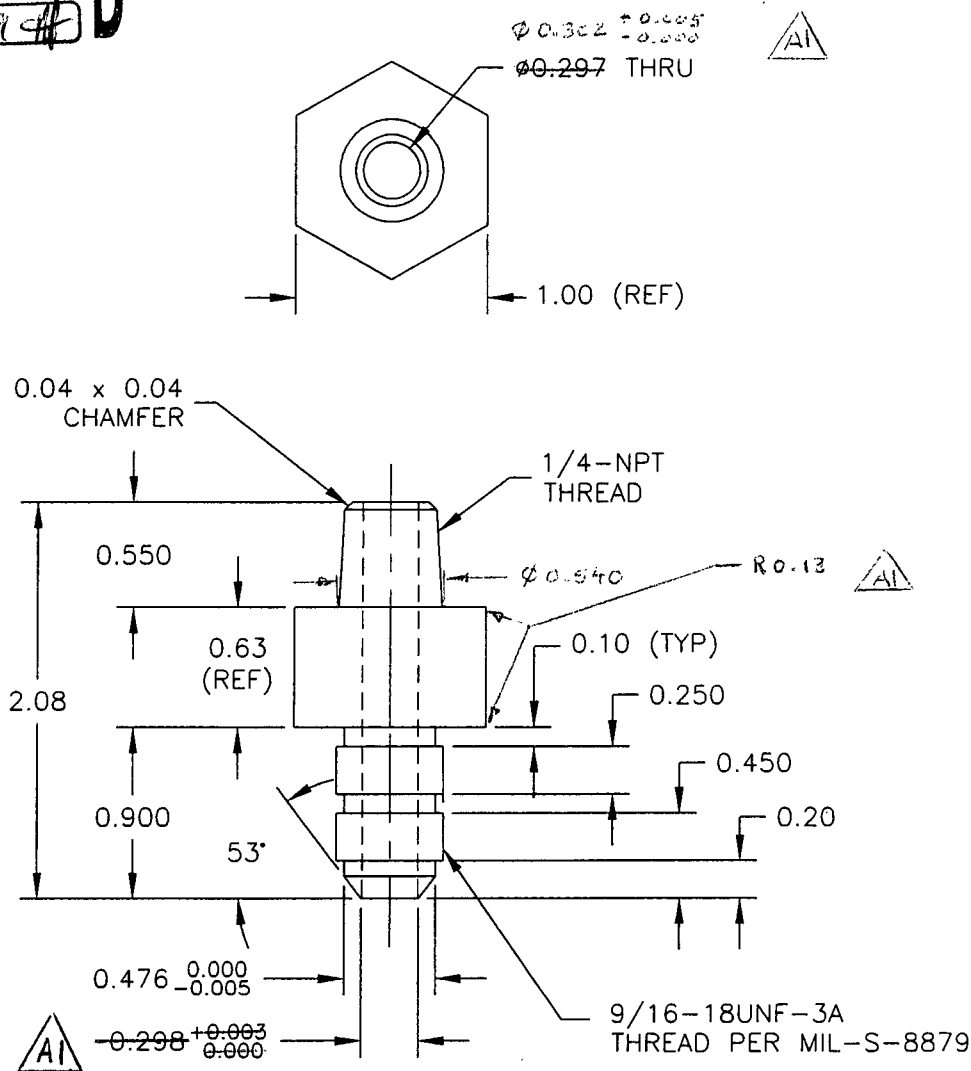
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3299	REV. A SHEET 2 OF 3
DATE 04.07.06		TITLE FITTING	SCALE 1:1

RELEASED  
04.09.09 [Signature]



**D3299-3**

**D3299-3 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1-000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY  
SUBJECT TO DISCONTINUED  
WITHOUT NOTICE

WORK ORDER  
NO. 22049

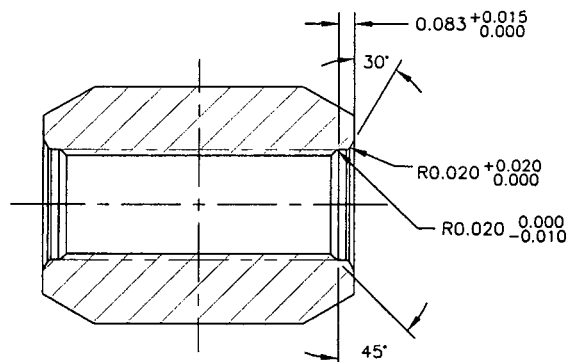
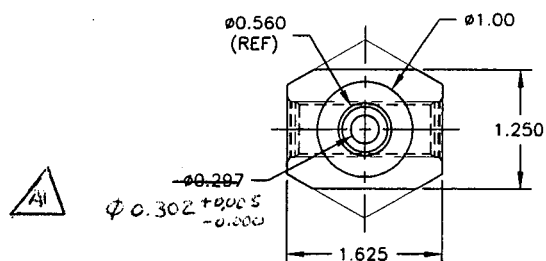
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

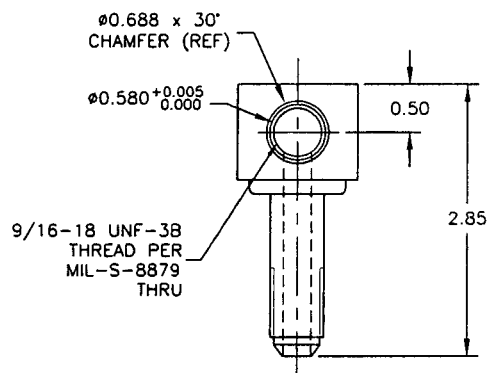
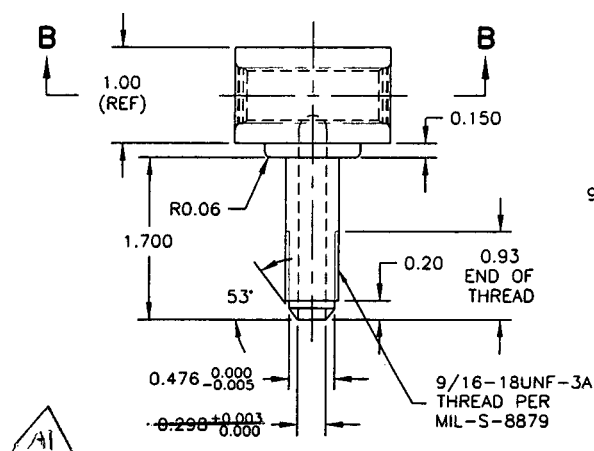


DESIGN <i>RT</i>	DRAWN BY <i>RT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3299	REV. A SHEET 3 OF 3
DATE 04.07.06		TITLE FITTING	SCALE 1:2

RELEASED  
04.04.04



SECTION B-B  
SCALE 1:1



D3299-5

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/B OR QQ-A-225/B) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 22049

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Dec 06, 2004  
11:09 am

Work Order No : 0022049  
Project Name : D3299-1  
Project For : WK503  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3299-1  
Description : Fitting  
Manufactured : Yes  
Amount Req'd : 10  
Amount Done : 0  
Start Date : 12-03-04  
Est Finish Date : 01-15-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

**TNM****ANODISATION et PEINTURE TNM INC.**

C. OF C

4454 Garand, Ville St. Laurent, QC H4R 2A2  
Telephone: (514) 335-7001 Fax: (514) 335-3920  
Certifié ISO 9001-2000 / ISO 9001-2000 certified  
Certifié NADCAP / NADCAP certified

**39237**

25-Feb-2005

**CLIENT / CUSTOMER:****DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE****PURCHASE ORDER/  
NO. DE COMMANDE: 2007621**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION		PART PROCESS & TREATMENT
1	9	9	D3299-1	B22049	DESC: FITTING BLUE ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER
2	9	9	D3299-3	B22050	DESC: FITTING BLUE ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER
3	6	6	D3299-5	B22051	DESC: FITTING BLUE ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

Nous certifions que les articles énumérés ont été procédés accordément à l'inspection ci-haut.  
Les cartes de travail ont été remplies et sont disponibles pour consultation sur demande.

We hereby certify that the above parts have been processed in accordance with the above inspection.  
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: \_\_\_\_\_

  
\_\_\_\_\_  
☐ Directeur de la Qualité / Q.A. Manager ☐ ☐ ☐